

**What is Claimed is:**

1. A method of manufacturing filled and sealed pouches using an apparatus comprising  
a conveyor support (1, 2, 17) and a conveyor (8, 10, 11, 21) which travels over the support and which  
has an upper surface which comprises a longitudinal side margin (46) along each side and a plurality of  
moulds (23) between the side margins, means (1, 14 and 24) for thermoforming a film into the mould to  
form pouches and means for filling and sealing the pouches, wherein the method comprises applying  
thermoformable film (29) on to the upper surface of the conveyor (8, 10, 11, 21), forming the pouches by  
thermoforming the film (29) into the moulds (23) while holding each side edge (45) of the film (29) to a  
side margin (46) of the conveyor to resist inward movement of the side edges (45), and  
filling and sealing the pouches and then discharging the pouches from the conveyor,  
wherein the holding of the side edges (45) of the film to the side margins (46) of the  
conveyor is by under-pressure applied to the underside of the film (29) through a plurality of holding  
orifices (44) which extend up through the conveyor and into each side margin (46) and which create  
friction forces which are sufficiently large to resist inward movement of the side edges (45) of the film  
during the thermoforming.
2. A method according to claim 1 in which the holding orifices (44) are arranged along each edge portion in a band (42) over which they are transversely distributed.

3. A method according to claim 2 in which the holding orifices (44) are arranged in two or more longitudinal rows within each band.
4. A method according to claim 1 in which the separation between adjacent holding orifices (44) is from about one to about five times the diameter of the orifices (44).
5. A method according to claim 1 in which each holding orifice (44) has a diameter of from about 1 to about 5mm.
6. A method according to claim 1 in which the outlet from each holding orifice (44) is surrounded by a material having a coefficient of friction of at least about 0.3.
7. A method according to claim 6 in which the material has a Shore hardness (grade A) of from about 10 to about 90.
8. A method according to claim 6 in which the material is formed of silicone rubber.
9. A method according to claim 1 in which the thermoforming is by under-pressure applied to the moulds (23).
10. Apparatus for manufacturing filled and sealed pouches comprising a conveyor support (1, 2, 17) and a conveyor (8, 10, 11, 21) which travels over the support and which has an upper surface which comprises a longitudinal side margin (46) along each side and a plurality of moulds (23) between the side margins, means (1, 14 and 24) for thermoforming a film into the moulds to form pouches, means for filling the pouches, and means for sealing the pouches and means for holding each side edge (45) of the film (29) to a side margin (46) of the conveyor to resist inward movement of the side edges (45), wherein the means for holding each side edge (45) of the film (29) to a side margin (46) of the conveyor comprises a plurality of holding orifices (44) which extend up through the conveyor and into each side margin (46) and means for applying under-pressure to the underside of the film through the holding orifices and thereby creating friction forces which are sufficiently large to resist inward

movement of the side edges (45) of the film (29) during thermoforming of the film into the moulds.

11. Apparatus according to claim 10 including means for applying an under-pressure into the moulds and thereby thermoforming the film into the moulds.

12. Apparatus according to claim 11 comprising also a vacuum supply apparatus, a row of vacuum apertures leading from the vacuum supply apparatus and discharging through the conveyor support, vacuum moulding orifices extending through the conveyor into each of the vacuum moulds for transferring under-pressure from the vacuum apertures to each of the moulds and wherein the vacuum holding orifices extend through the conveyor into the side margins of the conveyor for transferring under-pressure from the vacuum apertures to the side margins of the conveyor and the conveyor comprises a belt (8) which slides over and seals against the conveyor support (2).

13. Apparatus according to claim 10 in which the conveyor is formed of mould plates (21) fitted within platens (10) mounted on a belt (11), wherein the moulds (23) are formed in the mould plates (21).